

Tuesday, November 09, 2010 12:58:54 PM

Page 1

**Accept**

**Setup Start**

**Stop**

**Cust Item ID:**

**Customer:**

**Reference:**

### Tooling:

Date:

Run Start

**Date:**

**SPC (Y/N):**

Date:

**Stop**

**Insp.  
Stamp**

Revision Nbr

D4035

A

100

Weld per dwg A/R Aluminum rod Batch: 112860 0.00

**Large Fab**

## Memo

0.00

## Large Fab

- 1- Cut D4035-7 as per dwg D4035
- 2- Drill hole using DT9620 and chamfer holes as per dwg D4035
- 3- remove identification marks and deburr
- 4- Weld bushing in rib and grind weld flush as per dwg D4035

MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY.

SAD 10-11-64

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00

QC

## Memo

0.00

## Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_






NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries





**Work Order ID 63669**

Tuesday, November 09, 2010 12:58:54 PM

Page 2

Item ID: D4035-047 Accept  Setup Start   
Revision ID: Stop   
Item Name: Lid Rib Assembly, Aft (Light)  
Start Date: 11/9/2010 Start Qty: 2.00  Cust Item ID:  
Required Date: 11/16/2010 Req'd Qty: 2.00  Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start   
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00							
130  Packaging Packaging	Identify as per dwg & Stock Location: <i>B/c</i>  Memo	0.00 0.00							<i>Cpl 10-11-10</i>
140  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00							<i>10-11-18</i>

*CMF  
10-11-10*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Tuesday, November 09, 2010 12:58:54 PM

Page 1

Work Order ID: 63669

Parent Item: D4035-047

Parent Item Name: Lid Rib Assembly, Aft (Light)


Start Date: 11/9/2010

Required Date: 11/16/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP RevA: new issue DD 10.01.25 verified by:EC  
per dwg revA 10.03.15 verified by:EC  
IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4035-11  Bushing		Manufactured	No			100	Each	30.0000	2	4		<i>Pl 10.10.09</i>	

Location Loc Qty Loc Code

ST109 14

58376 14

WA 16

59749 16

M6061T6TS0.750W.06  
2

Purchased No

100 f 147.2282 1.875 3.947368



6061-T6 SQ Tube .75 x .75 x .062W

Location Loc Qty Loc Code

MAT 69.55297

114573 22.1055

114640 47.44747

MAT06 77.6752

103069 38.0526

104422 15.5263

16441 4.07

9671 20.0263

*SAD 10-11-09*

*1.9*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

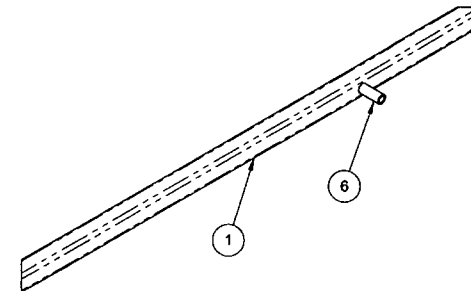
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

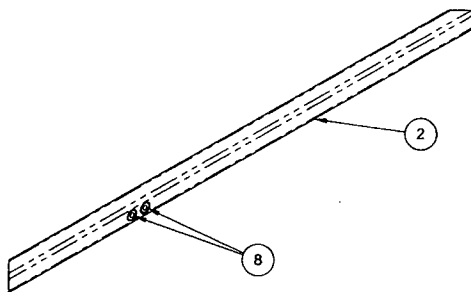
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

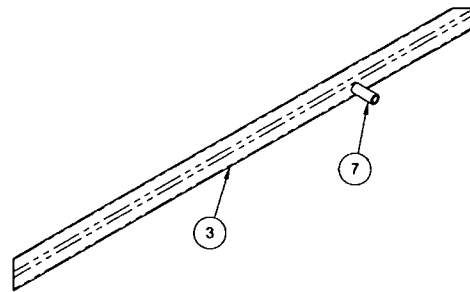
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
	X				D4035-041	LID RIB ASSY, FWD
		X			D4035-043	LID RIB ASSY, AFT
			X		D4035-045	LID RIB ASSY, FWD (LIGHT)
				X	D4035-047	LID RIB ASSY, AFT (LIGHT)
1	1				D4035-1	RIB
2		1			D4035-3	RIB
3			1		D4035-5	RIB
4				1	D4035-7	RIB
5				2	D4035-11	BUSHING
6	1				D2327-3	SPACER BUSHING
7			1		D2953-175	SPACER
8		2			D4021-9	BUSHING



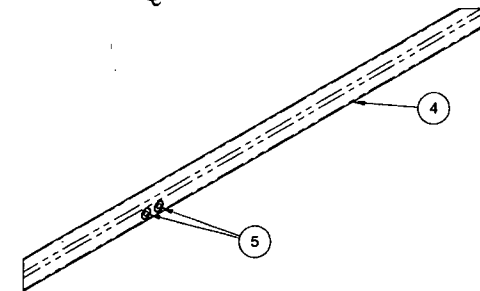
**D4035-041 BASKET LID RIB ASSY, FWD**



**D4035-043 BASKET LID RIB ASSY, AFT**



**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**



**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

**RELEASED**  
2010-03-12

A	NEW ISSUE	JPH	10.03.04
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	<b>DART AEROSPACE LTD</b>	
DRAWN	JPH	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 1 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
DATE	10.03.04	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



D4035-5  
RIB

D2953-175  
SPACER

**D4035-045 BASKET LID RIB ASSY, FWD (LIGHT)**

D4035-7  
RIB

D4035-11  
BUSHING  
2 PL

TYP

**D4035-047 BASKET LID RIB ASSY, AFT (LIGHT)**

#63669

**RELEASED**  
2010-03-12

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs
- 8) WELDING: PER DART QSI 004

DESIGN	AJS	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4035	SHEET 3 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET LID RIB ASSY	NTS
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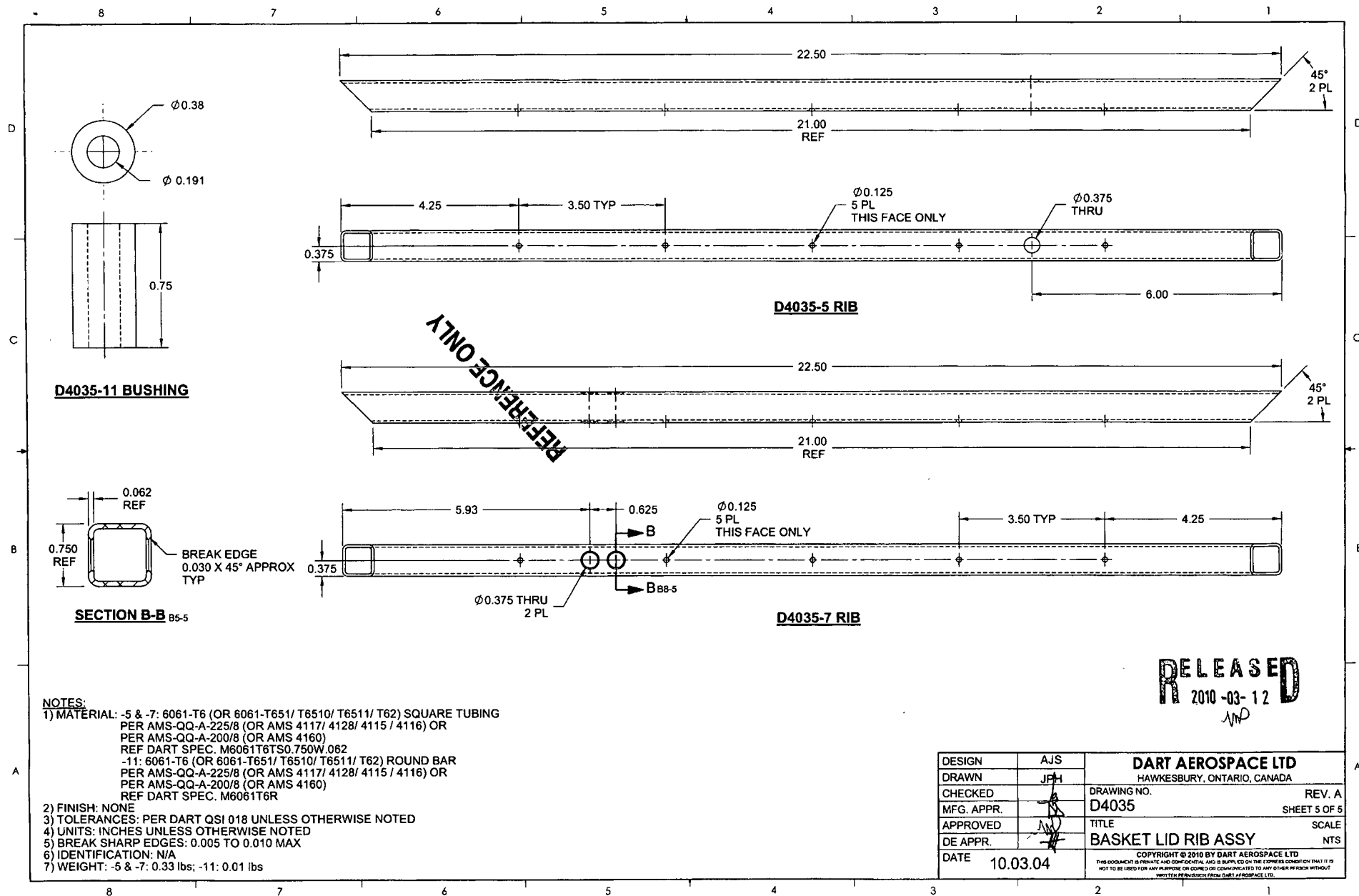
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



RELEASED  
2010-03-12  
AND

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO. D4035	REV. A
MFG. APPR.		TITLE BASKET LID RIB ASSY	SHEET 5 OF 5
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2010 BY DART AEROSPACE LTD	
DATE	10.03.04	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

## Receiving Report

Date: 10/5/10

Batch No: M114690

Supplier: TW Metal

Dart P/O: 11825

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☒ No ☐  
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☒ No ☐ N/A ☐  
 Shipment Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection ☒ 10/5/12 N/A ☒  
 Work Order ☐

### Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin: 10/5/11  
 Date [Signature]  
 Received/Costing [Signature]  
 Initial [Signature]

Location \_\_\_\_\_



P.O. Box 644  
Exton, PA 19341-0644

\* INVOICE \*

REMIT TO:

TW METALS, INC  
PO. BOX 933014  
ATLANTA

GA 31193-3014

FED ID: 25-0883470

RECEIVED MAY 13 2010

SALES OFFICE 585-768-5600

SOLD TO:

DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY ON K6A 1K7  
CANADA

SHIP TO:

DART AEROSPACE LTD  
1270 ABERDEEN ST  
HAWKESBURY ON K6A 1K7  
ONTARIO CANADA

PO11825		DATE ORDERED		DATE SHIPPED		INVOICE NUMBER
		05/05/10		05/05/10		80394474
SHIP	BAX 3-5 DAY	C	1203820	NET 30 DAYS		
QUANTITY					UNIT PRICE	AMOUNT
1	D6061-T6 3/4 SQ X .065 WA RD CORNER			120.000	FT	
	ECCN:EAR99			10	EA	
	LENGTH: 12 FT ML			3.5000	FT	420.00

.244  
. 1236

QUANTITY	UNIT PRICE	AMOUNT	SALES TAX	TOTAL INVOICE
1/1	420.00	.00	.00	420.00
ORIGINAL		IF PAID WITHIN DISCOUNT PERIOD DEDUCT	.00000	

**PACKING SLIP**

FROM: CHIC PAGE 1\*

EST. DATE: 05/11/10 CONFIRMED

RECEIVED

C. KGA JK7

QUANTITY  
1-5 BA.  
HOMERITE

LENGTH

12 FT BL  
120,000 FT

120,000

LENGTH  
12.5000

DATE SHIPPED

DATE FILLED

TERMS AND CONDITIONS APPLICABLE TO THE SALE  
OF THESE PRODUCTS ARE SET FORTH ON THE  
REVERSE SIDE FOR YOUR CAREFUL REVIEW.

# PACKING SLIP

FROM: CHIC

PAGE 2

24 713 RPO DATE: 05/11/10 CONFIRMED

REFERENCE IND

7213 05/11/10

CHIC

C K6A IK7

IN CHIC

www.farnell.com. MSDS  
and product statistics  
if you do not have web site access  
please contact a member of our current

to manufacture order and  
these have been manufactured,  
in production. These  
to Europe  
to Europe

DATE: 5/05/10

Exported from the United States in accordance  
of these products are set forth on the  
reverse side for your careful review.

TERMS AND CONDITIONS APPLICABLE TO THE SALE  
OF THESE PRODUCTS ARE SET FORTH ON THE  
REVERSE SIDE FOR YOUR CAREFUL REVIEW.

# KAISER ALUMINUM FABRICATED PRODUCTS

KAISER ALUMINUM  
FABRICATED PRODUCTS, LLC  
6573 W. WILLIS ROAD  
CHANDLER, AZ 85226

**CERTIFIED TEST REPORT**  
<http://Certs.KaiserAluminum.com>

CUSTOMER PO NUMBER: <b>M49225809-1</b>		CUSTOMER PART NUMBER: <b>86913</b>		PRODUCT DESCRIPTION: <b>Seamless Tube/Pipe</b>	
KAISER ORDER NUMBER: <b>205020</b>	LINE ITEM: <b>001</b>	SHIP DATE: <b>03/27/2010</b>	KAISER LOT NUMBER: <b>F00007573</b>	ALLOY: <b>6061</b>	TEMPER: <b>T6</b>
WEIGHT SHIPPED: <b>459.000 LB</b>	QUANTITY: <b>198.000 PCS</b>	B/L NUMBER: <b>204253</b>	DIAM/DAF/THKNS: <b></b>	WIDTH: <b></b>	LENGTH: <b>12.000 FT</b>
SHIP TO: <b>TW METALS INC 235 WEST TUBEWAY DRIVE CAROL STREAM, IL 60188 USA</b>			SOLD TO: <b>TW METALS INC 760 CONSTITUTION DRIVE SUITE 204 EXTON, PA 19341 USA</b>		

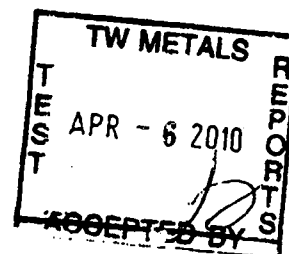
*S* → *12/12*

## Actual Physical Properties

REFERENCE	DASH#	SAMPLE#	UTS (KSI)	YTS (KSI)	ELONG%	HARDNESS	CON%IACS	BEND
F00007573	0001	1	48.7	46.5	15.9	N/A	N/A	N/A

## Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	Pb	Bi	Zr	Ea	Tot
Maximum	0.80	0.70	0.40	0.15	1.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
D67811	.59	.29	.24	.06	.96	.06	.06	.02	.00	.00	.00	.01	.02
D67767	.62	.33	.24	.05	.96	.09	.07	.03	.00	.00	.00	.01	.02



## CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ('Kaiser') hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file subject to examination.

Chris Garcia, Quality System Engineer

*Christopher J. Garcia*

Plant Serial: 00006613

Kaiser Order Number: 205020

Line Item: 001



**DART**  
aerospaceDART Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053**PURCHASE ORDER**

Purchase Order ID PO11825

Purchase Order Date 5/04/10

PO Print Date 5/04/10

Page Number 1 of 1

## Order From :

VU-TWM001

TW METALS  
PO BOX 933014  
ALTANTA, GA 31193-3014  
US

## Contact Name

Vendor Phone 585 768 5600

Vendor Fax 585 768 5601

Vendor Account Nbr

## Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr 10127-2607

Terms

Net 30

Currency

USD

FOB

## Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA**FAXED**  
67053

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6TS0.750W.062	6061-T6 SQ Tube .75 x .75 x .062W	5/11/10 Yes	✓ 120.00 f		\$3.5000	\$420.00

Special Inst: MATERIAL: 6061-T6 OR 6061-T62  
TUBING PER  
WW-T-700/6 OR AMS4080 OR AMS 4082  
OR  
QQ-A-200/8 OR QQ-A-225/8  
MATIAL: 6061-T6 SQUARE TUBING  
\*.750" X .750" X .065" WALL \*

PO Total:

\$420.00

**MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY**

PO Instructions: \* PLEASE SHIP: BAX GLOBAL ACCT:152700192 \*

Change Nbr: 1

Change Date: 5/04/10

No substitution or deviation without  
consent.Certificate of Conformity or Material  
Certification required when applicable